

Work Order ID 67036

Thursday, March 03, 2011 3:11:41 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: 11 Date: 11-03-3 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2580	Rev.D DEO-D1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG003

8 11/03/20

ck R B6 11/03/20

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender


1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

1 0 BE 11/03/20

B 6 7 0 3 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.03.25	140	Acceptable to use 0.049" wall XBOLT SPACERS				 11.03.25 951042	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
						1	0	BE11/03/21	
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends and remove bending marks								
	2- Prepare tube for swaging as per QSI 002								
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

11-3-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod

M116577

2-Grind welds on step as per Dwg D2580

BE11/03/21

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002
and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start
expansion and finish with 1/2 x 18G to achieve dwg dimension.

BE11/03/21

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

BB4/03/22

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Quality Control

Memo

0.00

D 4/03/23



W/O:		WORK ORDER CHANGES					
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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:
OVEN TEMPERATURE:
FINISH TIME:1:05
320
1:35

(70)

1 BR 11-3-23

1 BR 11-3-23

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

(IX) M-L 11/03/23

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

0.00

Hand Finishing

Memo

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M116040
Sikaflex expire date: 11/09

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M116040
Sikaflex expire date: 11/09

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: M116402

1 0 11/03/24

M 11/03/24

11/03/24

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

Sulz 3/25

220



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

P4/3/28 @

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CK 11/03/28

MF
11-03-28

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Picklist Print

Thursday, March 03, 2011 3:11:52 PM

Page 1

Work Order ID: 67036

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 3/3/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
 KJ IPP Rev P 10.02.19
 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
 10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 Spacer		Manufactured	No			140	Each	247.0000	20	20		BE11/03/21 B-67308	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				247					
					65529			26					
					66121			221					
D2580-1 205 Skidtube bent detail		Manufactured	No			110	Each	6.0000	1	1		BE11/03/21 B-67076	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				6					
					59856			1					
					65510			4					
					65511			1					
D2576-3 Step (maching detail)		Manufactured	No			140	Each	40.0000	1	1		BE11/03/21	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				40					
					52215			40					

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Page 2

Work Order ID: 67036

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 3/3/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200 Each

91.0000

1

1



Cap



m.h 11/03/23

Location

Loc Qty

Loc Code

FP6

1

56613

1

fp7

15

65519

15

ST024

75

50513

1

50770

28

51539

2

53791

9

65569

35

1X

AN3-5A

Purchased No

200 Each

711.0000

2

2



Bolt



m.h 11/03/23

Location

Loc Qty

Loc Code

ST350

711

115016

45

115371

500

116632

166

2X

AN960JD10L

~~NAS1149D03321~~ Purchased

No

200 Each

4.0000

2

2



Washer



m.h 11/03/23

Location

Loc Qty

Loc Code

ST335

4

11912

4

2X

M117010

Thursday, March 03, 2011 3:11:53 PM

Shop Packet Print

Page 2

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Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 3/3/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130 Purchased No

200 Each

1,654.000 50 50



Insert



m.d 11/03/23

Location

Loc Qty

Loc Code

FP 21
115079 21
ST282 1633
111529 32
113238 17
115502 500
115581 84
116800 ✓ 1000

AN3C4A Purchased No

200 Each

2,626.000 50 50



BOLT



m.d 11/03/23

Location

Loc Qty

Loc Code

ST350 2626
115300 25
116075 337
116704 564
116924 ✓ 1200
117010 500

AN960C10L NAS1149C0332 Purchased No

200 Each

61.0000 50 50



washer



m.d 11/03/23

Location

Loc Qty

Loc Code

ST245 61
107534 59
108246 2

M116304

50X

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Shop Packet Print

Page 3

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Parent Item Name: Replacement Skidtube

Start Date: 3/3/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D3566-13

Manufactured No

200

Each

64.0000

1

1



Gasket



m.d 11/03/23

Location

Loc Qty

Loc Code

FP011

36

66550

36

FP014

28

64070

11

66137

17

1X

D3566-5

Manufactured No

200

Each

43.0000

1

1



Gasket



m.d 11/03/23

Location

Loc Qty

Loc Code

FP015

43

63574

1

65528

13

66146

9

66552

20

1X

D3566-1

Manufactured No

200

Each

68.0000

2

2



Gasket



m.d 11/03/23

Location

Loc Qty

Loc Code

FP

20

66548

20

FP011

19

65525

19

FP015

29

57715

1

66040

20

66129

8

2X

67496

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Start Date: 3/3/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-11 Manufactured No

200 Each

22.0000

1

1



Wearshoe

66154



m. 2/11/03/23
1X

Location

Loc Qty

Loc Code

FP019

22

65159

8

66554

14

D3564-13 Manufactured No

200 Each

51.0000

1

1



Wearshoe



m. 2/11/03/23

Location

Loc Qty

Loc Code

FP16

28

65522

10

66549

18

FP17

23

59660

1

66136

22

D3564-9 Manufactured No

200 Each

23.0000

1

1



Wearshoe



m. 2/11/03/23

Location

Loc Qty

Loc Code

FP

1

55334

1

FP019

20

66153

20

FP19

2

62238

2

65524

1X

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Parent Item Name: Replacement Skidtube

Required Date: 3/18/2011

Required Qty: 1.00

Wearshoe

Loc Code

1

1

1

22

22

1

6

15

O-Ring, 205 Skidtube

Loc Code

19

12

12

500

472

472

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Start Date: 3/3/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

200

Each

744.0000

16

16



Plug, 205 Skidtube



m-k 11/03/23

Location

Loc Qty

Loc Code

FP	483
42807	112
55002	71
66122 ✓	300
FP14	261
58434	15
65512	133
65980	113

16X

W/O:		WORK ORDER CHANGES					
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DART**RELEASED**
07.06.28**DEO ATTACHED**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *67036*
0811-03-3

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07-06-28

DEO ATTACHED

Technical drawing of a circular component with the following callouts and dimensions:

- #0.208**: Dimension for the central hole.
- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Instruction for drilling two locations.
- SEAL WITH SIKAFLEX-241/-291**: Instruction for sealing the component.
- AN3-5A BOLT (1)**: Callout for a bolt.
- AN960JD10L WASHER (1)**: Callout for a washer.
- (2 PLACES)**: Dimension for the two places mentioned in the drilling instruction.
- D2855 CAP**: Callout for the cap.
- 0.40**: Dimension for the distance from the center to the edge of the cap.

D2579 SPACER

D2596 WEB (REF)

ALS7-1032-130 (REF)
(TYP 50 PLACES)

AFTER PERFORM

1. CHA
2. INS
3. WE
4. C'B

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C/BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

37.50
DISTANCE TO AFT END
OF D2596 WEB

3
7

1.750

1.750

0.508 (TYP.)
(40 PLACES)

REFER TO DETAIL A

8.750

17.375

26.000

34.188

57.313 (REF)

7 EQUAL SPACES
8.188 PITCH

38.0

91.500

190.0
(D2500-1)

WELD AS PER DETAIL B

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

0.5 1.5 1.5 0

1.5 1.5 1.5

△ B

P P P P P P P

REFER TO DETAIL C

D3566-1 D3566-5 D3566-1 D3566-13

D3564-11 D3564-5 D3564-9 D3564-13

AN304A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

DESIGN *dd* DRAWN BY *1*

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DESIGN

1

CHECKE

1

DATE _____

07.02

DRAWN BY

PH

APPROVED

4

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D2580

TITLE	
-------	--

205 SKIDTUBE ASSEMBLY

REV. D

SHEET 2 OF 3

SCALE

1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07-06-28

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{8}$

DETAIL G
SCALE 5:24

Technical drawing of a circular component with a central hole and a rectangular slot. The drawing includes the following labels and dimensions:

- #0.208**: Dimension for the central hole.
- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Instruction for drilling two locations.
- SEAL WITH SIKAFLEX-241/-291**: Instruction for sealing the component.
- AN3-5A BOLT (1)**: Label for the bolt used in the assembly.
- AN960UD10L WASHER (1)**: Label for the washer used in the assembly.
- (2 PLACES)**: Dimension for the two places where the bolt and washer are used.
- D2855 CAP**: Label for the cap used in the assembly.
- SEE NOTE ii)**: Reference to a note in the document.
- 0.40**: Dimension for the width of the rectangular slot.

Diagram of the rear view of a propeller. Labels include: D2579 SPACER, D2596 WEB (REF), and ALS7-1032-130 (REF) (TYP 50 PLACES). A list of steps is provided: 1. CHA, 2. INS, 3. WE, 4. C'B.

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO $\phi 0.437$ X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

[illegible]

Technical drawing of a curved pipe section. The drawing shows a side view of a pipe with a curved profile. Key dimensions and features include:

- Overall length: 51.340
- Distance from left end to first reference point: 5.338 (REF)
- Distance between reference points: 38.580
- Distance from second reference point to end: 5.915
- Radius of curvature: $\phi 0.508$ (8 PLACES)
- End radius: $\phi 0.640$
- Angle at left end: 4
- Angle at right end: 4
- Distance between hole and tangent point: 1.0
- Distance between hole and tangent point: 1.0
- Overall distance between holes: 32.0 \pm 1.0
- Left end offset: 1.4
- Left end offset: 13.4

[illegible]

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APPROVED	<i>H</i>

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO	D2580
TITLE	205 SK

REV. D
SHEET 3 OF 3
SCALE
1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2580-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>R</i>	APPROVED <i>MP</i>		DE APPR. <i>MP</i>		
DATE 10.09.22	DATE 10.11.04	DATE 10.11.04	DATE 10/11/04		DATE 10.11.04		

PURPOSE:

CHANGE ALL WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

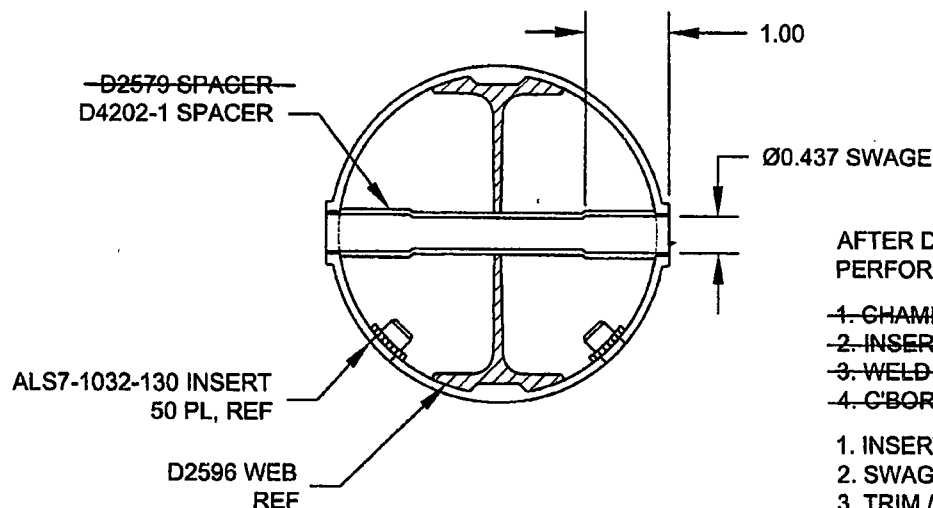
WAS

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-045		
20	24	D2579	CROSS BOLT SPACER

IS

20	24	D4202-1	SPACER
----	----	---------	--------

SECTION D-D & SECTION H-H ARE AMENDED AS FOLLOWS:



SECTION D-D
NOT TO SCALE

SECTION H-H
NOT TO SCALE

RELEASED
2010-11-18
MP

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 24 PL (-045)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries